

Tuesday, January 26, 2016 3:19:23 PM

Page 2

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

Work Order ID 141040

Tuesday, January 26, 2016 3:19:23 PM

141040

Page 3

Item ID: D2360

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Litter Tie Down Bracket

Start Date: 1/26/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/26/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

150

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M134371.

Memo

0.00

START TIME: 10:40

OVEN TEMPERATURE: 320°

FINISH TIME: 11:10

10 0 16-04-25 DAS 34 9-89

160

160

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

5x 16/08/04

170

170

Small Fab

Small Fab

Small Fab

DAS
22
9-89

0.00

Memo

Assemble as per dwg D2360

0.02

16.04.26

5x 16/08/04 DAS 36 9-89

* Drill Holes #D .246

Work Order ID 141040

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141040

Page 4

Item ID: D2360

Revision ID:

Item Name: Litter Tie Down Bracket

Start Date: 1/26/2016 Start Qty: 4.00

Required Date: 1/26/2016 Req'd Qty: 4.00

Reference:

4

4

N9000040100

Cust Item ID:

Customer:

Setup Start ***NS1***

Stop ***NS2***

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

180

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

(Handwritten: 45)

DAS
16
9-89

Kolaxoy

190

190

Packaging

Packaging

Identify as per dwg & Stock Location:

5t225
0.00

Memo

0.00

DAS
6
9-89

FC

AUG 0 4 2016

200

200

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.01

DAS
21
9-89

AUG 0 5 2016

DAS
21
9-89

AUG 0 5 2016

Picklist Print

Tuesday, January 26, 2016 3:19:22 PM

Work Order ID: 141040

141040

Parent Item: D2360

D2360

Parent Item Name: Litter Tie Down Bracket

Start Date: 1/26/2016

Required Date: 1/26/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev H 07.06.12 ecn 825 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R18

Purchased

No

170

Each

178.0000

1

**

AN526C1032R18

Screw

Location

Loc Qty

Loc Code

FP001

72

4523

72

ST327

106

108079

106

170

Each

17.0000

2

**

D2002-015

Manufactured

No

D2002-015

Knob

Location

Loc Qty

Loc Code

GA

17

136185

2

137686

15

170

Each

15.0000

1

**

D2345

Manufactured

No

D2345

Lock Channel

Location

Loc Qty

Loc Code

GA

15

133107

2

135400

3

136913

10

DAS
36
9-89DAS
36
9-89DAS
36
9-89B144888
5X

Picklist Print

Tuesday, January 26, 2016 3:19:22 PM

Work Order ID: 141040

141040

Parent Item: D2360

D2360

Parent Item Name: Litter Tie Down Bracket

Start Date: 1/26/2016

Required Date: 1/26/2016

Start Qty: 4.00

Required Qty: 4.00

D2366

Manufactured No

170

Each

7.0000

2

**

D2366

Lock Handle

LocationLoc QtyLoc Code

ST006

7

136142

7

170

Each

31.0000

1

**

D2367

Manufactured No

D2367

Handle Knob

LocationLoc QtyLoc Code

ST006

31

133384

4

135368

6

140046

21

170

Each

46.0000

2

**

D2372

Manufactured No

D2372

Quick Release

LocationLoc QtyLoc Code

GA

46

137780

6

137980

6

138467

6

139350

16

140020

12

170

Each

18.0000

1

**

D2373

Manufactured No

D2373

Spring

LocationLoc QtyLoc Code

GA

18

133415

8

140116

10

Picklist Print

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Page 3

Work Order ID: 141040

141040

Parent Item: D2360

D2360

Parent Item Name: Litter Tie Down Bracket

Start Date: 1/26/2016

Required Date: 1/26/2016

Start Qty: 4.00

Required Qty: 4.00

D2444

Manufactured No

170

Each

14.0000

1

X10

D2444

Pip Pin Assembly

**

16/08/04

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

14

136647

4

139614

6

140203

4

D6201

Manufactured No

100

f

41.1380

1.054

4.437895

D6201

"T" Extrusion

**

B141608 (6x)
B141073 (2x)
B144897 (2x)

DAS
14
9-89
11/04/13

Location

Loc Qty

Loc Code

MAT028

41.1380001

124165

0.0000001

133208

0.068

133910

1.07

137533

20

140069

20

MS20470AD3-4

Purchased No

170

Each

1,652.000

1

X10

MS20470AD3-4

Rivet, Universal Head

**

141301 → 11.07

Location

Loc Qty

Loc Code

GA

556

111477

556

ST310

1096

111477

1096

APR 26 2016 DAS
36
9-89

Picklist Print

Tuesday, January 26, 2016 3:19:22 PM

Page 4

Work Order ID: 141040

Parent Item: D2360

Parent Item Name: Litter Tie Down Bracket

141040

D2360

Start Date: 1/26/2016

Required Date: 1/26/2016

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

170

Each

2,597.000

3

MS21042L3

Nut

**

1230
1343(p)

APR 26 2016

Location

Loc Qty

Loc Code

CCK007

2000

m134039

2000

FP001

163

m133790

163

GA

195

m133790

195

ST304

239

m133790

239

M134360 (18x)

MS27039-1-13

Purchased

No

170

Each

688.0000

1

MS27039-1-13

Screw

**

A 10

Location

Loc Qty

Loc Code

GA

90

124326

90

over006

295

124326

295

ST280

303

125654

303

4
820

MS27039-1-15

Purchased

No

170

Each

506.0000

2

MS27039-1-15

Screw

**

Location

Loc Qty

Loc Code

GA

21

m127916

21

ST280

485

m132640

485

12
8

APR 26 2016

Picklist Print

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Tuesday, January 26, 2016 3:19:22 PM

Work Order ID: 141040

141040

Parent Item: D2360

D2360

Parent Item Name: Litter Tie Down Bracket

Start Date: 1/26/2016

Required Date: 1/26/2016

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0332J

Purchased

No

170

Each

1,611.000

8

32 80

**

NAS1149D0332.I

Washer

Location

Loc Qty

Loc Code

CA

14

m129682

14

FP001

60

m129682

60

GA

265

m132677 ←

265

48

ST260a

600

m133988

600

32

ST264

672

m133498

672

NAS1149D0363J

Purchased

No

170

Each

1,866.000

2

8 20

**

NAS1149D0363.I

Washer

Location

Loc Qty

Loc Code

GA

84

m130799

84

ST260a

1000

m134055 ←

1000

12

ST263

782

m133790

282

m133932

500

APR 26 2016
DAS
B
2-85

Picklist Print

Tuesday, January 26, 2016 3:19:23 PM

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Work Order ID: 141040

141040

Parent Item: D2360

D2360

Parent Item Name: Litter Tie Down Bracket

Start Date: 1/26/2016

Required Date: 1/26/2016

Start Qty: 4.00

Required Qty: 4.00

NAS679A3W

Purchased

No

170

Each

262.0000

1

410

NAS679A3W

Nut

**

16/08/04
NAS
76
9-89

Location

Loc Qty

Loc Code

GA

140

1463

5

M2409

135

Mezz

122

2409

122

10

DART AEROSPACE LTD		Work Order: 141040
Description: Litter Tie Down Bracket (Locking)		Part Number: D2341
Inspection Dwg: D2341	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

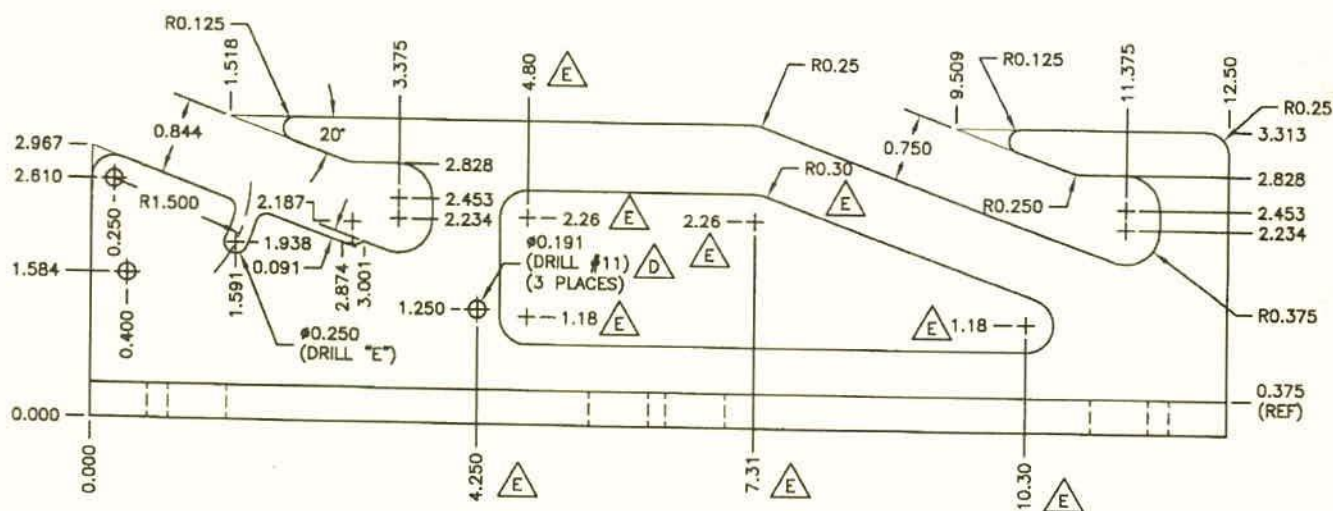
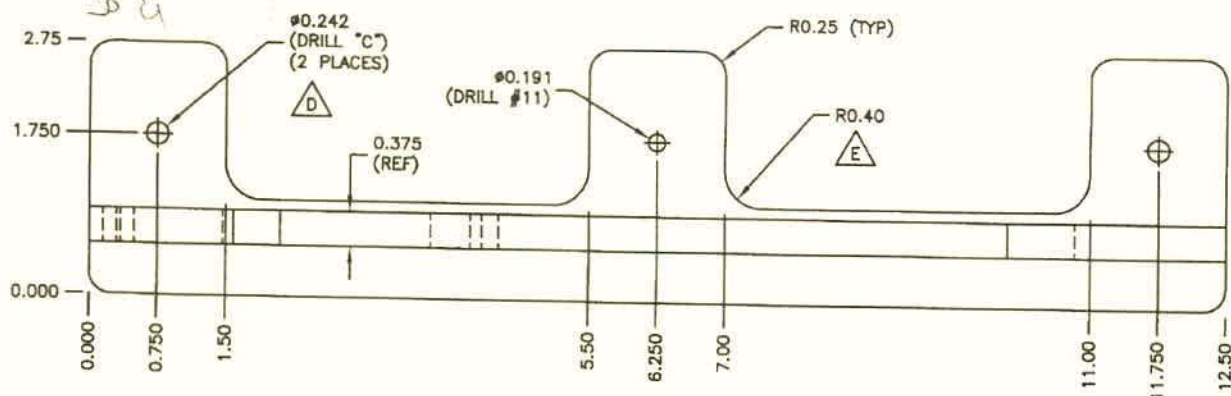
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.750	+/-0.010	1.751	✓		SLIC	Vern
2.75	+/-0.030	2.754	✓			
Ø0.242	+0.005/-0.001	0.242	✓			
Ø0.191	+0.005/-0.001	0.191	✓			
R0.25	+/-0.030	0.250	✓			
R0.40	+/-0.030	0.400	✓		Rad gauge	
12.50	+/-0.030	12.507	✓		Height gauge	
11.750	+/-0.010	11.755	✓			
11.00	+/-0.030	11.002	✓			
7.00	+/-0.030	7.007	✓			
6.250	+/-0.010	6.255	✓			
5.50	+/-0.030	5.503	✓			
1.50	+/-0.030	1.504	✓			
0.750	+/-0.010	0.748	✓		SLIC	Vern
0.400	+/-0.010	0.3955	✓			
1.584	+/-0.010	1.5815	✓			
2.610	+/-0.010	2.6075	✓			
0.250	+/-0.010	0.248	✓			
0.844	+/-0.010	0.844	✓			
Ø0.250	+/-0.010	0.249	✓			
0.750	+/-0.010	0.751	✓			
3.313	+/-0.010	3.312	✓			
4.250	+/-0.010	4.248	✓			
1.250	+/-0.010	1.247	✓			

Measured by: DAS 20 9-89	Audited by: H. 08 9-89	Prototype Approval: N/A
Date: 16-04-14	Date: 16/04/15	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	10.02.02	Dimensions updated	KJ	

DART

DESIGN BW	DRAWN BY BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED /B	APPROVED /H	DRAWING NO. D2341	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER TIE DOWN BRACKET (LOCKING)	SCALE 1:2
A	95.01.13	NEW ISSUE	
B	95.02.14	MODIFIED LOCK	
D	95.02.20	CHANGES TO DIAMETERS	
E	97.10.01	CHANGES FOR MACHINING	
F	07.06.07	REVISED NOTES; FINISH WAS ANODIZE	

**D2341 LITTER TIE DOWN BRACKET (LOCKING)**

- (F)
- 1) MATERIAL: MAKE FROM D6201-D125 EXTRUSION (6061-T6/T651 PER QQ-A-200/8)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.010
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFY WITH DART P/N "D2341" USING FINE POINT PERMANENT INK MARKER

RELEASED

07-6-22

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DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED [Signature]	DRAWING NO. D2360	REV. D
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	SHEET 1 OF 2
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
D	07.06.06	D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5)	

RELEASED

07 06 07

PARTS LIST:

QTY	PART NUMBER	DESCRIPTION
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2002-015	KNOB (DELRIN)
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
8	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT (OR MS21042-3)
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT

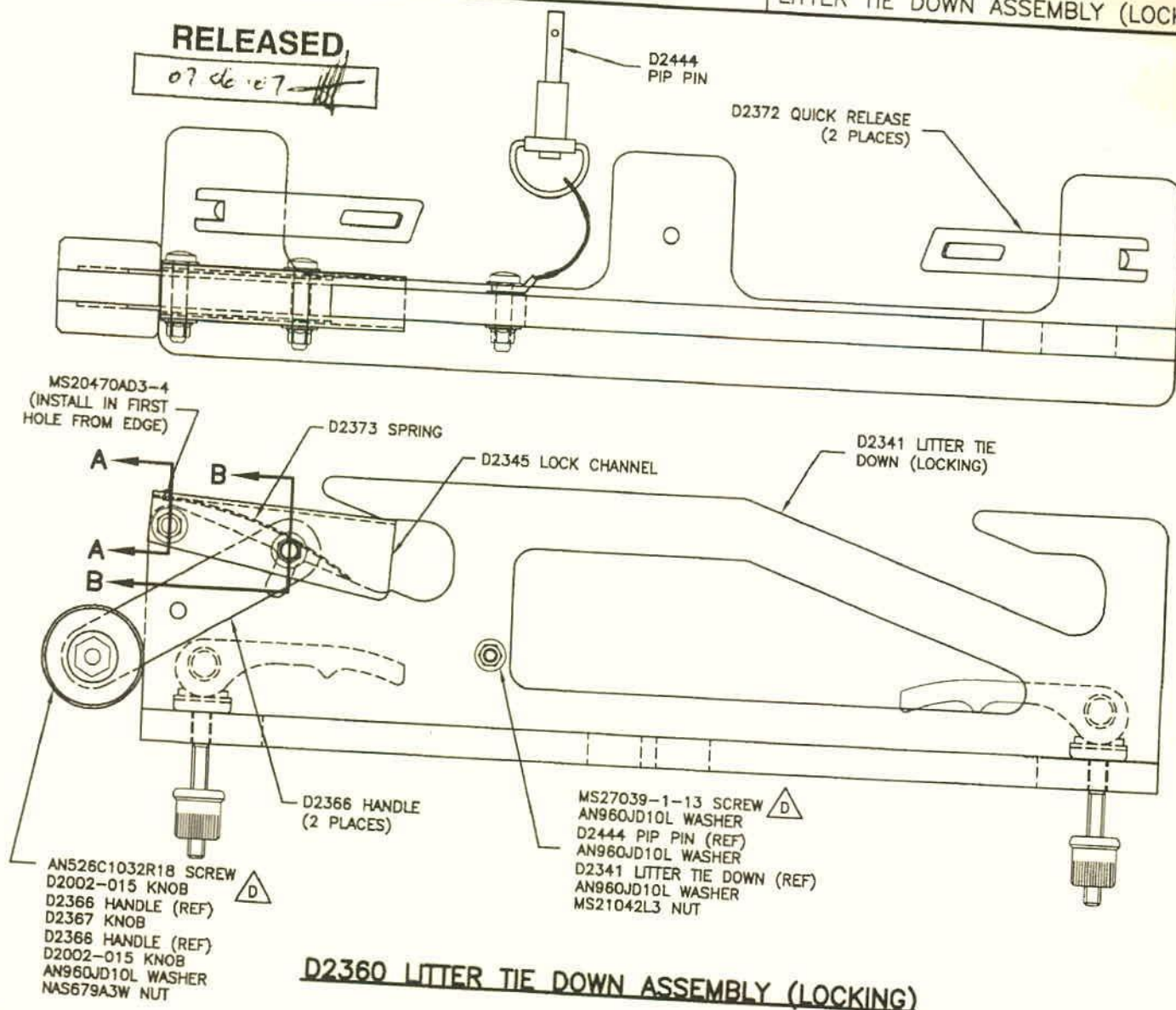


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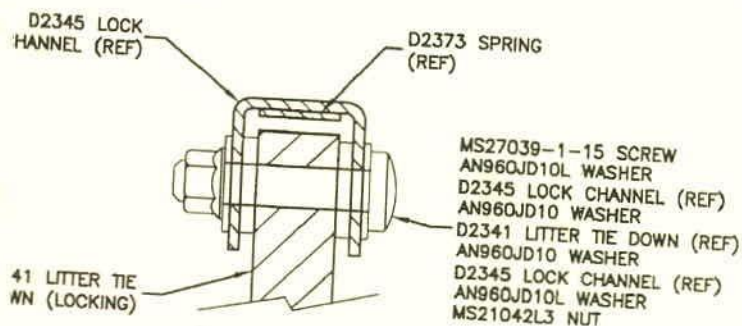
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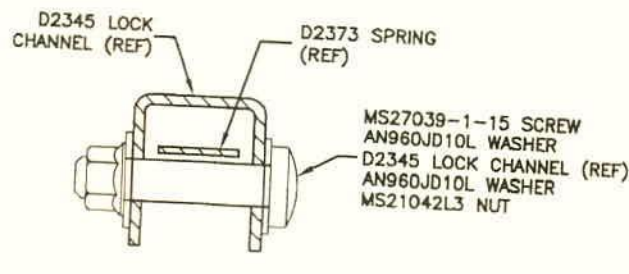
DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. D
CHECKED CE	APPROVED H	DRAWING NO. D2360	SHEET 2 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	SCALE



D2360 LITTER TIE DOWN ASSEMBLY (LOCKING)



SECTION A-A
(SCALE 1:1)



SECTION B-B
(SCALE 1:1)